

# ENVIRONMENTAL PRODUCT DECLARATION

as per *ISO 14025* and *EN 15804+A1*

Owner of the Declaration	Stahlwerk Thüringen GmbH
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-STH-20210014-IAB1-EN
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Valid to	10/10/2026

Structural Steel: Sections  
Stahlwerk Thüringen GmbH

[www.ibu-epd.com](http://www.ibu-epd.com) | <https://epd-online.com>



## 1. General Information

### Stahlwerk Thüringen GmbH

#### Programme holder

IBU – Institut Bauen und Umwelt e.V.  
Panoramastr. 1  
10178 Berlin  
Germany

#### Declaration number

EPD-STH-20210014-IAB1-EN

#### This declaration is based on the product category rules:

Structural steels, 11.2017  
(PCR checked and approved by the SVR)

#### Issue date

11/10/2021

#### Valid to

10/10/2026



Dipl. Ing. Hans Peters  
(chairman of Institut Bauen und Umwelt e.V.)



Dr. Alexander Röder  
(Managing Director Institut Bauen und Umwelt e.V.)

### Structural Steel: Sections

#### Owner of the declaration

Stahlwerk Thüringen GmbH  
Kronacher Straße 6, D 07333 Unterwellenborn  
HR B 202 875, Amtsgericht Jena, Ust. - Id. Nr.: DE 150 536 120

#### Declared product / declared unit

The declared unit is 1 ton of average structural steel sections

#### Scope:

This environmental product declaration covers steel products rolled out to structural sections and steel sleepers, intended for bolted, welded or otherwise connected constructions of buildings, bridges, rail constructions and other structures.

This EPD is valid for hot-rolled sections and steel sleepers produced by Stahlwerk Thüringen GmbH (Germany).

The production shares in this EPD are 100% Electric Arc Furnace route (secondary steel production) based on the total yearly production volume.

The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of *EN 15804+A1*. In the following, the standard will be simplified as *EN 15804*.

#### Verification

The standard *EN 15804* serves as the core PCR

Independent verification of the declaration and data according to *ISO 14025:2010*

☐ internally ☒ externally



Therese Daxner  
(Independent verifier appointed by SVR)

## 2. Product

### 2.1 Product description/Product definition

This EPD applies to 1 ton of structural steel sections. It covers steel products of the grades S235 to S460 rolled out to structural sections.

For the placing on the market of the product in the European Union/European Free Trade Association (EU/EFTA) (with the exception of Switzerland) *Regulation (EU) No. 305/2011* (CPR) applies. The product needs a declaration of performance taking into consideration *EN 10025-1* Hot rolled products of structural steels – Part 1: General technical delivery conditions and the CE-marking.

For the application and use the respective national provisions apply.

### 2.2 Application

Structural steels are intended for bolted, welded or otherwise connected constructions of buildings, bridges and other structures, or in composite steel and concrete structures. Examples are:

- single storey buildings (industrial and storage halls, etc.)
- multi-storey buildings (offices, residential buildings, shops, car parks, high rise, etc.)
- bridges (railway bridge, road bridge, pedestrian bridge, etc.)
- railway construction, track structure
- other structures (power plants, stadiums, convention centres, airports, stations, etc.)



### 2.3 Technical Data

This EPD is valid for sections, channels and steel sleepers of varied grades and different dimensions. Specific information on dimension tolerances, constructional data as well as mechanical and chemical properties can be found in the relevant literature and/or the standards.

#### Constructional data

Name	Value	Unit
Density	7850	kg/m <sup>3</sup>
Modulus of elasticity	210000	N/mm <sup>2</sup>
Coefficient of thermal expansion	12	10 <sup>-6</sup> K <sup>-1</sup>
Thermal conductivity	48	W/(mK)
Melting point depending on the alloy proportions up to	1536	°C
Share Modulus	81000	N/mm <sup>2</sup>

Stahlwerk Thüringen GmbH supplies to customers all over the world and produces therefore steel sections according to harmonized European standards with or without CE marking as well as international standards (American Society for Testing and Materials, ASTM standards) with the following performance data.

- Performance data of the product in accordance with the declaration of performance with respect to its essential characteristics according to *EN 10025-1*, Hot rolled products of structural steels
- Performance data of the product according to the harmonised standards, based on provisions for harmonization: *EN 10225-2*, Weldable structural steels for fixed offshore structures
- Performance data of the product with respect to its characteristics in accordance with the relevant technical provision (no CE-marking): *ASTM A36*, *ASTM A572*, *ASTM A992* and *ASTM A709*.

### 2.4 Delivery status

The dimensions of the declared products may vary according to the intended application.

### 2.5 Base materials/Ancillary materials

Structural steels are non-or low-alloy steel products whose carbon content is between 0 and 0.6%. Iron is the main component of steel sections. The content of other elements is significantly less. The exact chemical composition varies depending on the steel grade.

#### Auxiliary materials and alloys:

The rates of these additives depend on the steel grade and are on average: 0,7 % silico manganese, 0,3 % ferro manganese, 0,1% ferro silicon and < 0,1% other alloys (ferro niobium, ferro vanadium, ferro titanium, aluminium). The considered products do not contain substances listed in the "Candidate List of Substances of Very High Concern for Authorisation" (SVHC) (19.01.2021) exceeding 0.1 percentage by mass.

1) This product contains substances listed in the *candidate list* (date: 19.01.2021) exceeding 0.1 percentage by mass: No.

2) This product contains other carcinogenic, mutagenic, reprotoxic (CMR) substances in categories 1A or 1B which are not on the *candidate list*, exceeding 0.1 percentage by mass: No.

3) Biocide products were added to this construction product, or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) Ordinance on Biocide Products No. 528/2012): No.

### 2.6 Manufacture

In the electric steel production route, scrap is molten in an electric arc furnace to obtain liquid steel.

Refining (lowering of sulfur, phosphorous and other tramp elements) and alloying (e.g. about 1% Mn, 0.2% Si) and/or micro-alloying (e.g. about 0.04% Nb) is applied to give the requested characteristics to the steel.

At the end of the steelmaking process, the liquid steel is transformed into a semi-finished product in a continuous casting machine.

The semi-product (beam-blank) is hot-rolled into the final product dimensions (H-shape, I-shape, U-shape).

Quality control: *ISO 9001* Monitoring according to the product standards, e.g. *EN 10025*.

### 2.7 Environment and health during manufacturing

No measures relating to safety, health and environment protection during the manufacturing process extending beyond national guidelines are required.

### 2.8 Product processing/Installation

#### Processing recommendations:

Planning, processing, implementation and intended use of section constructions have to be carried out depending on the respective applications according to the generally recognized rules of engineering and manufacturer's recommendations.

The standards of *EN 1993* and *EN 1994* (Eurocode EC3 and EC4) apply to the design of steel structures and composite steel and concrete structures. They include the requirements regarding serviceability, bearing capacity, durability and fire resistance of steel structures EC3 and composite steel and concrete structures EC4.

The Standard Parts 1+2 of *EN 1090* apply to the execution of steel structures and include the requirements for factory production control. In addition, the European Standards will work in connection with national amendments, national instructions, guidelines and publications, as well as legal provisions.

Regarding transport and storage of sections, the generally accepted requirements for securing loads have to be observed.

Instruction details of the manufacturer based on verified standards and guidelines regarding welding, galvanizing as well as hot and cold forming are to be observed in every case.

#### Occupational safety/Environmental protection:

When processing/using steel sections according to the generally recognized rules of engineering there are no

measures to be taken which are going beyond the public occupational health and safety.

#### Residual material:

During processing residual pieces as well as turnings are to be collected separately. This scrap steel can be entirely recycled by melting and producing new steel products.

#### 2.9 Packaging

Structural steels are delivered bundled with steel straps. Packaging is not considered within the LCA.

#### 2.10 Condition of use

Structural steels are non-/low-alloyed steel products generated by alloying iron with other metals and non-metals (esp. carbon). Iron is the main component of steel sections. The components are listed under chapter 2.5 "Base materials". During usage, no changes in material composition shall occur.

#### 2.11 Environment and health during use

The intended use of sections does not endanger health or the environment in any known way.

#### 2.12 Reference service life

The reference service life is not relevant for consideration of the LCA. As construction products with many different applications, a reference service life for structural steel as sections is not declared here.

The purpose, possible corrosion protection and adequate maintenance are decisive for service life.

Description of the influences on the ageing of the product when applied in accordance with the rules of technology.

#### 2.13 Extraordinary effects

##### Fire

The material is class A1, i.e. not flammable per EN 13501.

The material does not emit fumes or fire gases.

##### Fire safety

Name	Value
Building material class acc. EN	A1

13501-1

#### Water

Steel is stable to water, insoluble and does not emit substances in water. In case of flooding, no impacts are to be expected.

Steel can corrode in the presence of oxygen in the water (= slow oxidation).

#### Mechanical destruction

Due to the ductility of steel, steel structures react resilient in the event of unforeseeable mechanical destruction: In case of tensile load, necking will occur before cracking. In case of lasting high compression load, components of steel may buckle or bulge. No splintering or breaking edges should result.

#### 2.14 Re-use phase

##### General:

Sections of steel are recyclable by 100%. Due to the magnetic properties of steel, 97% of the used steel is regained after dismantling European Commission Technical Steel Research.

##### Re-use:

Sections can be re-used. It is expected that around 14% of the products are re-used after dismantling.

##### Recycling:

Sections can be recycled without any problems after dismantling. It is expected that around 83% of the products are used for closed-loop recycling.

Data from industry estimates based on the following sources: *European Commission Technical Steel Research*

#### 2.15 Disposal

Due to its high value as a resource, steel scrap is not disposed but instead fed into a well-established cycle of reuse or recycling. However, in the case of dumping due to collection loss, no environmental impacts are expected.

Waste code according to European Waste Catalogue EWC: 17 04 05 - iron and steel

#### 2.16 Further information

Additional information on constructing with steel can be obtained from [bauforumstahl.de](http://bauforumstahl.de).

### 3. LCA: Calculation rules

#### 3.1 Declared Unit

The reference unit is 1 ton of structural steel sections. Foreground data for the production are integrated into the software model for the considered production site/company. LCI is assessed as per the annual production data of Stahlwerk Thüringen GmbH at the site Unterwellenborn.

##### Declared unit

Name	Value	Unit
Declared unit	1	t
Conversion factor to 1 kg	1000	-

#### 3.2 System boundary

Type of the EPD: cradle-to-gate.

Module A1-A3 were considered including the following:

- On-site production via Electric Arc Furnace (EAF) and Section rolling
- Provision of materials and energies, including transportation.
- Steel scrap consumed within the EAF is considered burden-free.

All electricity consumed to produce the structural steel sections is produced from 100% hydropower in Europe, with 0,0061 kg CO<sub>2</sub>e/kWh. The study did not consider the packaging of the product.

### 3.3 Estimates and assumptions

Due to lack of available datasets for some alloying elements (e.g. Ferro-Vanadium) South-African data sets were used instead of local data. However, amounts of these elements are very low and the use of South-African data sets would be the “worst-case” assumption for European production, so the set-up scenario is considered a conservative approach.

### 3.4 Cut-off criteria

All information from the data collection process has been considered; covering all used materials, thermal energy, electrical energy, etc. Measurement of emissions took place and was considered. No processes, materials or emissions that are known to contribute significantly to the environmental impact of the products under study have been omitted. All input or outputs contributing more than 1% to the overall mass or energy of the system were considered. It can be assumed, that the sum of all excluded inputs and outputs contribute less than 5% to the impact assessment categories. The manufacturing of required machinery and other infrastructure is not considered in the LCA.

### 3.5 Background data

For the life cycle modelling of the product under study, the *GaBi Software System for Life Cycle Engineering*, content version 2021.1, is used (*GaBi Software*). The *GaBi database* contains consistent and documented datasets which can be viewed in the online GaBi-documentation (*GaBi Documentation*).

### 3.6 Data quality

The foreground data collected by the manufacturer are based on yearly production amounts and extrapolations of measurements on specific machines and plants. The production data refers to the years 2016.

All relevant background datasets are taken from the *GaBi Software* database and are representative of the years 2017-2021.

The study is based on high-quality data.

### 3.7 Period under review

The foreground data collected by Stahlwerk Thüringen are based on annual production amounts referring to the year 2016.

### 3.8 Allocation

Steel production via the electric arc furnace (EAF) generates EAF slag and scales as co-products. The EAF process that produces these co-products cannot be further sub-divided into sub-processes related to each co-product, so allocation is required.

The allocation method used here for EAF slag was developed by the *World Steel Association* and *EUROFER* to be in line with *EN 15804*. The methodology is based on physical allocation taking into account how changes in inputs and outputs affect the production of co-products.

Scales generated during steelmaking are sold for interior application in the automotive industry. To address the use of scales within other industry applications economic allocation is applied.

### 3.9 Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account.

For the life cycle modelling of the product under study, the *GaBi Software System for Life Cycle Engineering*, content version 2021.1, is used (*GaBi Software*).

## 4. LCA: Scenarios and additional technical information

Since no scenarios are declared, no additional technical information is required.

## 5. LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE NOT DECLARED; MNR = MODULE NOT RELEVANT)

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	MND	MND	MND	MNR	MNR	MNR	MND	MND	MND	MND	MND	MND	MND

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A1: 1 ton Structural Steel: Section

Parameter	Unit	A1-A3
Global warming potential	[kg CO <sub>2</sub> -Eq.]	3.85E+2
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	1.21E-12
Acidification potential of land and water	[kg SO <sub>2</sub> -Eq.]	7.80E-1
Eutrophication potential	[kg (PO <sub>4</sub> ) <sup>3</sup> -Eq.]	8.12E-2
Formation potential of tropospheric ozone photochemical oxidants	[kg ethene-Eq.]	6.68E-2
Abiotic depletion potential for non-fossil resources	[kg Sb-Eq.]	1.65E-4
Abiotic depletion potential for fossil resources	[MJ]	4.35E+3

### RESULTS OF THE LCA - RESOURCE USE according to EN 15804+A1: 1 ton Structural Steel: Section

Parameter	Unit	A1-A3
Renewable primary energy as energy carrier	[MJ]	2.69E+3
Renewable primary energy resources as material utilization	[MJ]	0.00E+0
Total use of renewable primary energy resources	[MJ]	2.69E+3
Non-renewable primary energy as energy carrier	[MJ]	4.50E+3
Non-renewable primary energy as material utilization	[MJ]	0.00E+0
Total use of non-renewable primary energy resources	[MJ]	4.50E+3
Use of secondary material	[kg]	1.08E+3
Use of renewable secondary fuels	[MJ]	0.00E+0
Use of non-renewable secondary fuels	[MJ]	0.00E+0
Use of net fresh water	[m³]	3.36E+0

### RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES according to EN 15804+A1: 1 ton Structural Steel: Section

Parameter	Unit	A1-A3
Hazardous waste disposed	[kg]	9.79E-7
Non-hazardous waste disposed	[kg]	2.41E+0
Radioactive waste disposed	[kg]	4.64E-2
Components for re-use	[kg]	0.00E+0
Materials for recycling	[kg]	0.00E+0
Materials for energy recovery	[kg]	0.00E+0
Exported electrical energy	[MJ]	0.00E+0
Exported thermal energy	[MJ]	0.00E+0

All electricity consumed for the production of the structural steel sections is produced from 100% hydropower in Europe

## 6. LCA: Interpretation

This chapter contains an interpretation of the Life Cycle Impact Assessment categories with regards to the declared unit. It focuses on the dominant contributions during the production stage.

Global Warming Potential (GWP), Acidification Potential (AP), Eutrophication Potential (EP) and Photochemical Ozone Creation Potential (POCP) are mostly caused by onsite emissions as well as extraction and processing of raw materials.

Ozone Depletion Potential (ODP) is mostly caused by emissions from the pre-chains of alloying and auxiliary materials.

Abiotic Depletion (elements) relates to the use of non-renewable elements in the production of alloying materials e.g., ferromanganese. Abiotic Depletion Potential (fossil) is dominated by the extraction and processing of raw materials (alloys, auxiliaries) and the generation of natural gas.

Total use of renewable primary energy carrier (PERT) is dominated by the generation of electricity from

hydropower. The total use of non-renewable primary energy (PENRT) is dominated by the extraction and processing of raw materials and the generation of natural gas.

Radioactive waste comes from the extraction and processing of raw materials. Non-hazardous wastes include overburden and tailings. Hazardous waste for deposition is mainly produced during the generation of natural gas.

This EPD applies to 1 metric ton of structural steel sections. It covers steel products of the grades S235 to S460 rolled out to structural sections in different shapes/sizes. The average data of the annual production are representative for all steel products covered by the declared average. The variance in results is negligible. In addition, for modelling and calculation of the EPD results a conservative approach was followed.

## 7. Requisite evidence

This EPD covers semi-finished structural steel of hot-rolled construction products. Further processing and fabrication depend on the intended application. Therefore, further documentation is not applicable.

### 7.1 Weathering performance

The rusting rate of unalloyed steel depends on the position of the component and the conditions of the

surrounding atmosphere (corrosivity categories according to *ISO 12944-2*.

If required, the surfaces of fabricated structural components are usually protected with anticorrosion material in order to prevent any direct contact with the atmosphere. The weathering of this protection depends on the applied protection system.

## 8. References

### ASTM A 36

Standard specification for carbon structural steel

### ASTM A572

Standard Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel

### ASTM A709

Standard Specification for Structural Steel for Bridges

### ASTM A992

Standard specification for structural steel shapes

### Candidate List of Substances of Very High Concern for Authorisation

Candidate List of substances of very high concern for Authorisation, 2021, ECHA, [echa.europa.eu](http://echa.europa.eu)

### EN 1090

Execution of steel structures and aluminium structures

### EN 10025-1

Hot rolled products of structural steels

### EN 10025-2

Hot rolled products of structural steels

### EN 13501

Fire classification of construction products and building elements

### EN 15804

EN 15804:2012+A2:2019, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products

### EN 1993

Eurocode 3, Design of steel structures

### EN 1994

Eurocode 4, Design of composite steel and concrete structures

### European Commission Technical Steel Research

Sansom, M. and Meijer, J.: Life-cycle assessment (LCA) for steel construction, European Commission technical steel research, 2001-12

### EWC

European Waste Catalogue, European Commission

### ISO 9001

Quality management systems – Requirements

### ISO 12944-2

Paints and varnishes - Corrosion protection of steel structures by protective paint systems - Part 2: Classification of environments

### ISO 14025

DIN EN /ISO 14025:2011-10/, Environmental labels and declarations — Type III environmental declarations — Principles and procedures

### IBU 2021

IBU 2021, General Instructions for the EPD programme of Institut Bauen und Umwelt e.V. Version 2.0, Berlin: Institut Bauen und Umwelt e.V., 2021 [www.ibu-epd.de](http://www.ibu-epd.de)

### CPR

Regulation (EU) No 305/2011 of the European Parliament and of the Council of 9 March 2011 laying down harmonised conditions for the marketing of construction products and repealing Council Directive 89/106/EEC Text with EEA relevance

### GaBi Documentation

GaBi, Software and Database for Life Cycle Engineering, Sphera, Leinfelden-Echterdingen, 2021, <http://documentation.gabi-software.com>

### GaBi Software

GaBi, Software and Database for Life Cycle Engineering, Sphera, Leinfelden-Echterdingen, 2021

### PCR 2016, Part A

Product Category Rules for Building-Related Products and Services, Calculation Rules for the Life Cycle Assessment and Requirements on the Project Report. Institut Bauen und Umwelt e.V. (IBU) March 2018 [www.bau-umwelt.de](http://www.bau-umwelt.de)

**PCR 2016, Part B**

Requirements on the EPD for Structural steels - Institut Bauen und Umwelt e.V., Königswinter (pub.): From the range of Environmental Product Declarations of

Institute Construction and Environment e.V. (IBU), 2017

**World Steel Association and EUROFER**

Methodology to determine the LCI of steel industry co-products, 2013



**Publisher**

Institut Bauen und Umwelt e.V.  
Panoramastr. 1  
10178 Berlin  
Germany

Tel +49 (0)30 3087748- 0  
Fax +49 (0)30 3087748- 29  
Mail [info@ibu-epd.com](mailto:info@ibu-epd.com)  
Web [www.ibu-epd.com](http://www.ibu-epd.com)

**Programme holder**

Institut Bauen und Umwelt e.V.  
Panoramastr 1  
10178 Berlin  
Germany

Tel +49 (0)30 - 3087748- 0  
Fax +49 (0)30 – 3087748 - 29  
Mail [info@ibu-epd.com](mailto:info@ibu-epd.com)  
Web [www.ibu-epd.com](http://www.ibu-epd.com)

**Author of the Life Cycle  
Assessment**

Sphera Solutions GmbH  
Hauptstraße 111- 113  
70771 Leinfelden-Echterdingen  
Germany

Tel +49 711 341817-0  
Fax +49 711 341817-25  
Mail [info@sphera.com](mailto:info@sphera.com)  
Web [www.sphera.com](http://www.sphera.com)

**Owner of the Declaration**

Stahlwerk Thüringen  
Kronacher Straße 6  
07333 Unterwellenborn  
Germany

Tel +49 3671 4550 0  
Fax +49 3671 4550 7107  
Mail [info@stahlwerk-thueringen.de](mailto:info@stahlwerk-thueringen.de)  
Web [www.stahlwerk-thueringen.de](http://www.stahlwerk-thueringen.de)